

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021618**Date Inspected:** 12-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

This QA Inspector randomly observed the following work in progress.

OBG LIFT 14 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 058087 performing the Shielded Metal Arc Welding process on weld 169 located at PCMK SEG3019BB. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066418 performing the Shielded Metal Arc Welding process on weld 125 located at PCMK SEG3019BB. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037932 performing the Shielded Metal

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Arc Welding process on weld 013 located at PCMK SEG3019V. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067610 performing the Shielded Metal Arc Welding process on weld 227 located at PCMK SEG3019S. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066326 performing the Shielded Metal Arc Welding process on weld 107 located at PCMK SEG3019Q. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066763 performing the Flux Cored Arc Welding process on weld 157 located at PCMK SEG3019BB. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067877 performing the Flux Cored Arc Welding process on weld 069 located at PCMK SEG3019BB. ZPMC QC Mr. Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing for the repair areas of the weld between FB3286 and bottom panel, Weld detail as "T" joint CJP weld. Weld number identified as SEG3019D-1-323.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066236 performing the Flux Cored Arc Welding process on weld 002 located at PCMK SEG3019U. ZPMC QC Mr. Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

OBG 13 EAST

This QA Inspector observed ABF QA Inspector performing Ultrasonic Testing for the deck panel splice between DPDP3091 and DP3092. During the Ultrasonic Testing ABF QA Inspector discovered 17 rejectable longitudinal linear indications. Weld number identified as SEG3009-007.

This QA Inspector observed erection/installation of deck panels DP3074, DP3073, DP3075 was in progress in OBG segment 13AE.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
